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D4712-1**Job Sheet 201735****Part No:** D4712-1**Job Qty:** 12 pcs**Part Name:** Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/9/19**Job Tracking No:****Due Date:** 10/24/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV C SHEETS 2,3 IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		10/24/19	0.17	0.77	Waterjet - Flow		JRB 6/27/19
120	QC 8	12 pcs		10/24/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		DAS OCT 30 2019 40 9-89
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC - B4B	12 pcs		10/24/19	0.25	0.46	Small Fab - Brake - 1 - B4B		DAS 30 NOV 6 1 2019 9-89
							Small Fab - Brake - 2 -		

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**Container No:** S226769**Part:** D4712 - 1**Job No:** 201735**Serial No/Batch:** S226769**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 10/27/19

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10/9/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				B4B	
140 QC 5	12 pcs	10/24/19	0.00 0.00	Small Fab - Brake - 3 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	12 pcs	10/24/19	0.00 0.40	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	12 pcs	10/24/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	

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https://www.plexonline.com/c6f0d62a-0981-4631-9b6a-3c7d051d7150/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 3/4

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	10/24/19	0.00 0.00	QC 21 - SA - 21	NOV 06 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Bend/Assemble as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location:) mfooy
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	1.0500 sf (.0875 ea)	100-Waterjet - Flow - 1	5 204169

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	1	303	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.630Inches + 0.008 - 0.001	0.638 0.629	Diameter	0.629
2	Bracket	2.350Inches ± 0.030	2.380 2.320		2.35
3	Bracket	1.300Inches ± 0.010	1.310 1.290		1.303
4	Bracket	1.800Inches ± 0.030	1.830 1.770		1.797
5	Bracket	0.900Inches ± 0.030	0.930 0.870		0.897
6	Bracket	0.500Inches ± 0.030	0.530 0.470		0.507
7	Bracket	1.200Inches ± 0.030	1.230 1.170		1.201
8	Bracket	2.500Inches ± 0.030	2.530 2.470		2.502
9	Bracket	3.800Inches ± 0.030	3.830 3.770		3.801
10	Bracket	5.000Inches ± 0.030	5.030 4.970		5.000
11	Bracket	0.221Inches + 0.006 - 0.001	0.227 0.220	Diameter	0.222
12	Bracket	0.129Inches ± 0.010	0.139 0.119		0.130
13	Bracket	6.000Inches ± 0.030	6.030 5.970		6.005
14	Bracket	0.040Inches ± 0.010	0.050 0.030		0.039

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐															
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)															
Description Work Order Deviation				Disposition															
Root Cause				FAULT CATEGORY															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			